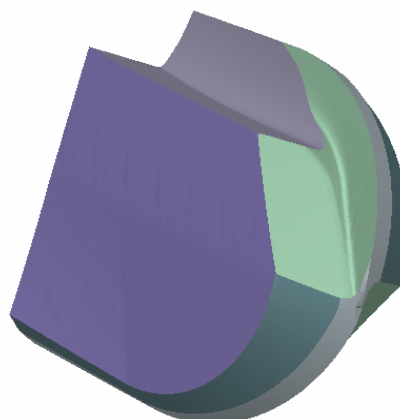










Ballnose Insert Ø25.4 Z2

A8-500

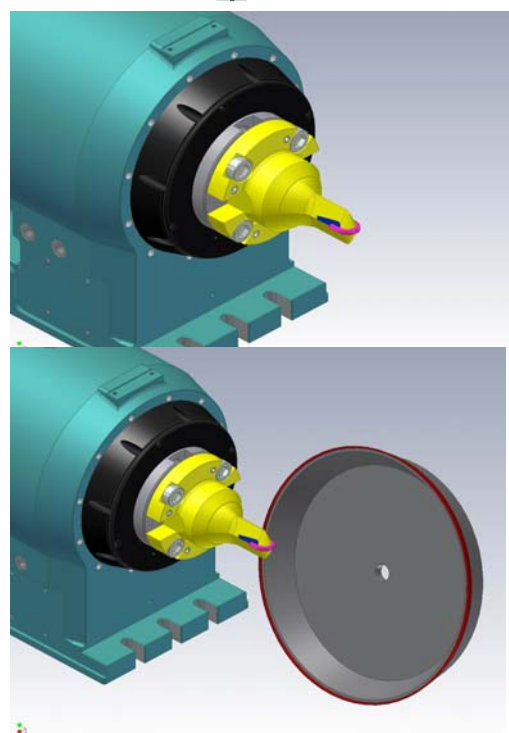
The ballnose Insert is ground as an insert automatically clamped in an appropriate automatic system using the standard ballnose operations. Therefore the single inserts are easy loadable with our integrated loadingrobot STL650 from double or stackpalettes.



1. Cycletime for Production

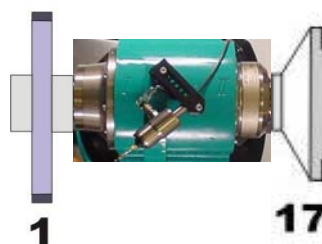
Tool specifications				
Diameter 25.4 mm, Z 2, Length 29 mm, Helix angle 4°				
Material HM				
Operations				
Feed [mm/Min]	90	150	200	300
Power [kW]	4	2	1	1
Cutting feed [m/s]	22	22	22	22
				
Used wheels	1	1	17	17
Grinding time [s]	53	24	145	91
Total cycle time	5 Min 12			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1 Ø300 1A1 D64
17 Ø300 12A2 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, Automatic Clamping, STL650
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2, Ballnoseoption

responsible engineer: OP, 29.3.07

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TECHNOLOGY
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